

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021936**Date Inspected:** 07-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lu Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG, Steel Barrier**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

BAY 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW), and Flux Cored Arc Welding (FCAW) processes.

ZPMC QC is identified as Zhan Hai Feng.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component: Edge Beam

PCMK: SEG3019AZ

Weld Number: 249

Welder: 066733

WPS-B-P-2231-ESAB

Component: Side Plate

PCMK: SEG3019AW

Weld Number: 100

Welder: 215553

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WPS-B-P-2212-TC-U4b-FCM-1

Component: Side Plate

PCMK: SEG3019AW

Weld Number: 096

Welder: 054013

WPS-B-P-2212-TC-U4b-FCM-1

Component: I Ribs

PCMK: SEG3019Q

Weld Number: 121, 123

Welder: 050969

WPS-B-P-2213-TC-U4b-FCM-1

Component: I Ribs

PCMK: SEG3019L

Weld Number: 060, 066

Welder: 044779

WPS-B-P-2213-TC-U4b-FCM-1

BAY 16

This QA Inspector observed the following work in progress for Bay 16.

ZPMC was using the Shielded Metal Arc Welding (SMAW), and Flux Cored Arc Welding (FCAW) processes.

ZPMC QC is identified as Guo Xing Hui.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component: Steel Barrier

PCMK: E5-SB25-002

Weld Number: 126~131

Welder: 222396

WPS-B-P-2132-ESAB

Component: Steel Barrier

PCMK: E5-SB23-001

Weld Number: 053, 054

Welder: 048625

WPS-B-T-2132-ESAB

Component: Steel Barrier

PCMK: E5-SB25A-002

Weld Number: 032~043

Welder: 053753

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WPS-B-P-2113

Component: Steel Barrier

PCMK: E5-SB25B-001

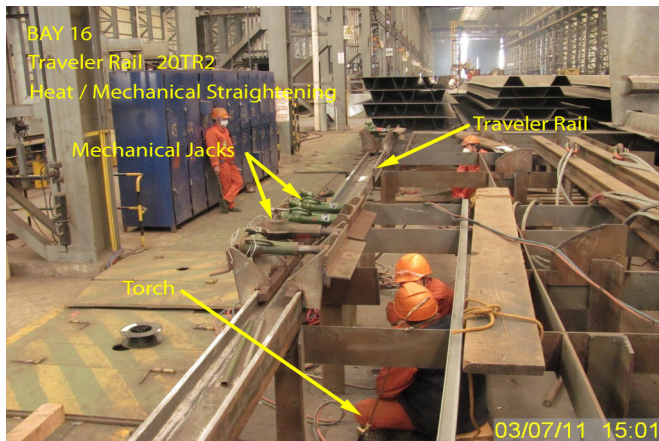
Weld Number: 050, 081

Welder: 062096

WPS-B-T-2231-ESAB

Heat straightening of PCMK, Traveler Rail 20TR2, under approved Heat Straightening procedure, HSR 1 (B)-10166, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Ma Qian Li. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 8mm.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Combs,Dennis	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
